



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2580-1

Job Sheet 203980



Part No: D2580-1

Job Qty: 10 pcs

Part Name: 205 Bent Tube



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/2/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 12/20/19

Description:

Note: DWG D2580 REV h SHEETS 1,2,3,8 IPP B 01.11.08 Revised Step 9, 10, 12, and 13 SM IPP Rev:C 10.12.01
as per DEO D1 DD ver:ec

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Skidtubes - 1	10 pcs	12/20/19		0.00	9.26	Skidtubes - 1		[Signature]
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
101	QC 5	10 pcs	12/20/19		0.00	0.00	QC 5 - 10		[Signature]
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
110	Handfinish - 1-1 Chemical-B4B	10 pcs	12/20/19		0.00	4.17	Handfinish - 1 - 1 - B4B		[Signature]
							Handfinish - 1 - 2 - B4B		
							Handfinish - 1 - 3 -		



Dart Aerospace Ltd.
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CANADA
TEL.: 1 (613) 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S245666



Part: D2580-1

Job No: 203980

Serial No/Batch: S245666

Revision: H

Inspector:

Exp Date:

Instructions: Various STC's

Date: 01/08/20

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				B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
120	QC 7	10	12/20/19	0.00 0.00	QC 7 - 10
		pcs			QC 7 - 13
					QC 7 - 14
					QC 7 - 15
					QC 7 - 17
					QC 7 - 18
					QC 7 - 19
					QC 7 - 2
					QC 7 - 28
					QC 7 - 3
					QC 7 - 30
					QC 7 - 34
					QC 7 - 36
					QC 7 - 37
					QC 7 - 41
					QC 7 - 47
					QC 7 - 48
					QC 7 - 51
					QC 7 - 58
					QC 7 - 59
					QC 7 - 60
					QC 7 - 9
					QC 7 - 68
					QC 7 - 50

				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
				QC 7 - 61	
				QC 7 - 81	
				QC 7 - 76	DAS
				QC 7 - 79	83
					9-89
125 Skidtubes - 2 - B4B	10 pcs	12/20/19	0.00 9.26	Skidtubes - 1 - B4B	
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	TF
				Skidtubes - 5 - B4B	
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
130 QC 5	10 pcs	12/20/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	BE
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
140 Packaging 3-1 - Stock - B4B	10 pcs	12/20/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	

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					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	TF
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					150 QC 21 - SA	10 pcs
					12/20/19	0.00 0.00
					QC 21 - SA - 21	DAS
					QC 21 - SA - 70	21
					QC 21 - SA - 53	8-89

JAN 14 2020

Part Op 100 - (Skidtube) 1- Inspect mat'l D2500-1-190 for damage. 2-Drill pilot holes using drill jig DT 8149 A-BC-D 3-Open holes Descriptions: to 0.508" as per Dwg D2580 4-Deburr holes per QSI002 section 4.2.3 and blow out all chips from inside of tube 5- Test fit inspection saddles on FWD & AFT saddle holes using DT9916.

101 - (QC5- Inspect part completeness to step on W/O)

110 - (Chemical Conversion Coat per QSI005 4.1)

120 - (QC7-Inspect Chemical Conversion Coat)

125 - (Skidtube) 1- Bond web in place per QSI 015. A/R Sikaflex-291 batch: 8231095 Sikaflex expire date: 03.18.2020 Start time and date: 10:30am Jan 13 20 bond for 12hrs

130 - (QC5- Inspect part completeness to step on W/O)

140 - (Identify as per dwg & Stock Location: LG002) LOCATION : LG002

150 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2500-1-190	Ext'n -1' Beam Tube 4"	10 pcs (1 ea)	100-Skidtubes - 1	5168374
D2596	Web, 205 Skidtube	10 pcs (1 ea)	125-Skidtubes - 2 - B4B	5220732 x4
				5245763 x6

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Skidtubes - 1	D2500-1-190	10	112	0
125-Skidtubes - 2 - B4B	D2596	10	4	0

Part Specifications

Specifications could not be found.

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2017 JUL 05 4
RELEASED

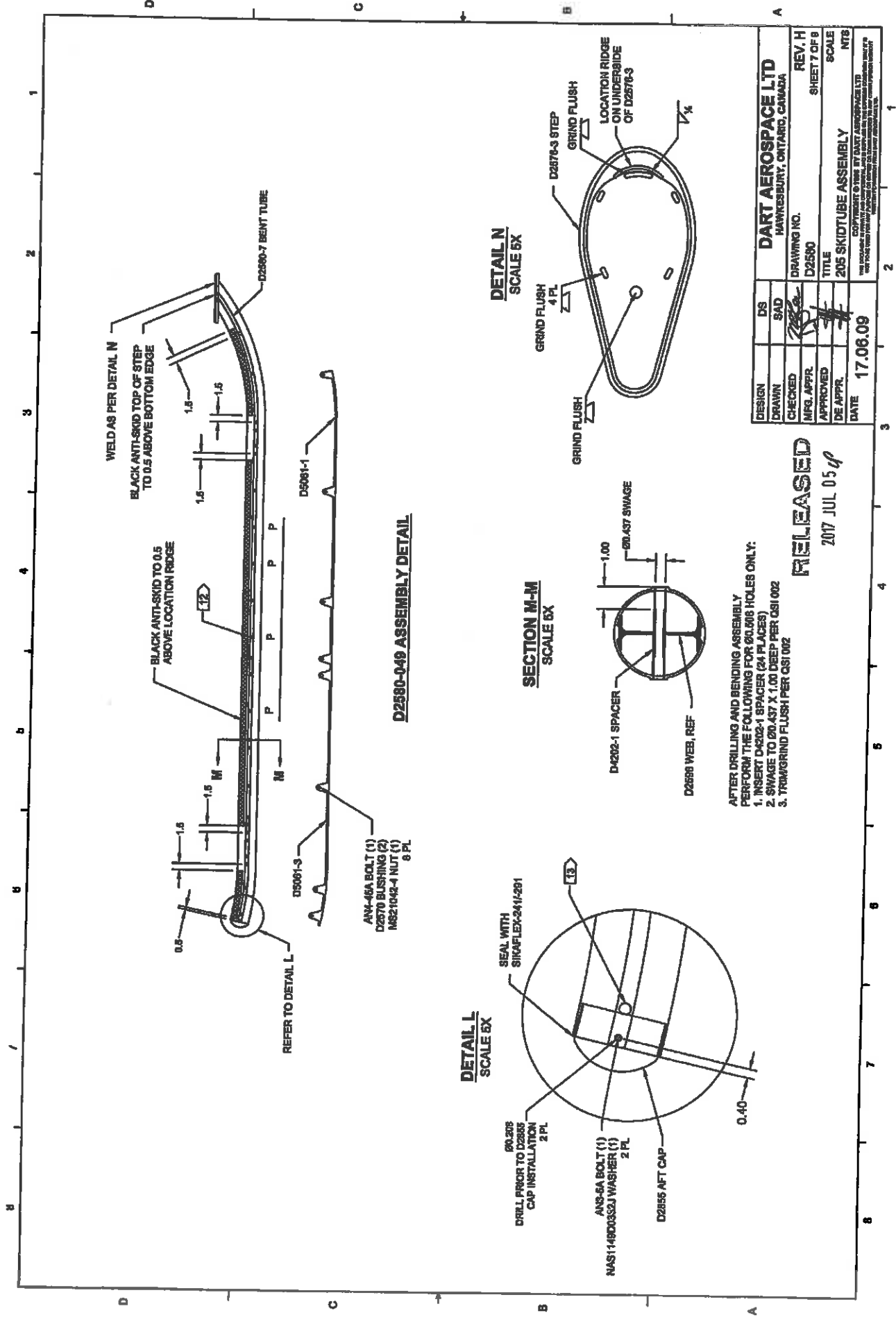
DESIGN	DS	DART AEROSPACE LTD HAMMERSBURY, ONTARIO, CANADA DRAWING NO. D2580 REV. H SHEET 3 OF 9 SCALE NTS CONTRACT NO. 1001 BY DART AEROSPACE LTD THIS DRAWING IS THE PROPERTY OF DART AEROSPACE LTD. IT IS TO BE USED ONLY FOR THE PROJECT AND FOR THE QUANTITY ORDERED. IT IS NOT TO BE REPRODUCED OR USED FOR ANY OTHER PURPOSE WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.
DRAWN	SAD	
CHECKED	<i>[Signature]</i>	
APPROVED	<i>[Signature]</i>	
DATE	17.06.09	
		205 SKIDTUBE ASSEMBLY TITLE 205 SKIDTUBE ASSEMBLY NTS



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2017 JUL 05 42

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2580 REV. H SHEET 6 OF 9 SCALE NTS 205 SKIDTUBE ASSEMBLY CUSTOMER OF 205B IS DART AEROSPACE LTD WE warrant the accuracy of the information furnished to us by our customer. If the customer is not a member of the DART Group, we warrant that the information was obtained from a reliable source.
DRAWN	SAD	
CHECKED	<i>MS</i>	
APPROVED	<i>[Signature]</i>	
DATE	17.06.09	



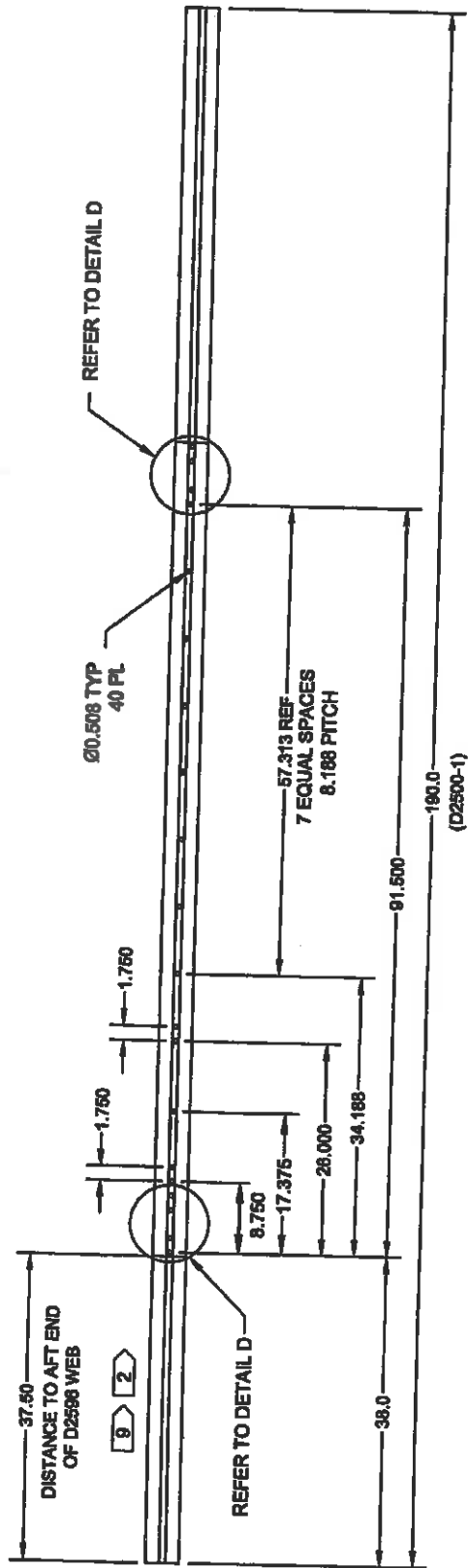
AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.006 HOLES ONLY:

1. INSERT D4202-1 SPACER (24 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER CSI 002
3. TRIM/GRIND FLUSH PER CSI 002

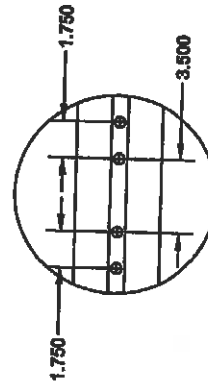
RELEASED
2017 JUL 05

DESIGN	DS	SAD	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	CHECKED	DATE	DRAWING NO.
MFG. APPR.	APPROVED	TITLE	D2580
DE APPR.	DATE	SCALE	205 SKIDTUBE ASSEMBLY
	17.06.09	NTS	

REV. H
SHEET 7 OF 8
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA



D2580-101 TUBE



DETAIL D
SCALE 5X

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2017 JUL 05

DESIGN	DS	DART AEROSPACE LTD
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA
CHECKED	WEL	DRAWING NO. D2580
MFG. APPR.		REV. H SHEET 9 OF 9
APPROVED		TITLE 205 SKIDTUBE ASSEMBLY
DE APPR.		SCALE NTS
DATE	17.06.09	CONFIRMED BY DART AEROSPACE LTD

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Entered: _____

Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐		MRB (QSI042)	
Date : _____		Sequence #: _____		QTY Affected : _____			
Description Work Order Deviation		Disposition					
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐							
Completed By		Lead hand / Supervisor					
QC / QA Coordinator		Other/Details:					